

## Claims:

1. A writing instrument in which an ink impregnated into an ink occlusion body in a barrel is fed to a pen tip in a writing part, wherein the ink impregnated into the ink occlusion body described above is fed to the pen tip via an ink guiding feed having visibility, and a sign of exhausting the ink fed from the ink occlusion body is detected by visually observing the ink guiding feed described above via a visible part formed in the barrel.

2. A writing instrument of a twin type in which an ink impregnated into an ink occlusion body in a barrel is fed to respective pen tips in writing parts disposed at both sides of the barrel, wherein the ink fed to either of the pen tips is fed to the pen tip via an ink guiding feed having visibility, and a sign of exhausting the ink fed from the ink occlusion body is detected by visually observing the ink guiding feed described above via a visible part formed in the barrel.

3. The writing instrument as described in claim 1 or 2, wherein the ink impregnated into the ink occlusion body is fed to the ink guiding feed having visibility via an inter-feeder.

4. The writing instrument as described in claim 3, wherein the inter-feeder is brought into contact with the inside of the ink occlusion body in a length of 5 % or more based on an overall length of the ink occlusion body.

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5. The writing instrument as described in claim 3 or 4, wherein the inter-feeder has a cross-sectional area of 1 to 90 % based on a cross-sectional area of the ink occlusion body.

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6. The writing instrument as described in any of claims 3 to 5, wherein the inter-feeder has larger capillary force than that of the ink occlusion body.

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7. The writing instrument as described in any of claims 3 to 6, wherein the inter-feeder has a cross-section structure comprising an inner layer and an outer layer, and the outer layer has larger capillary force than that of the inner layer.

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8. The writing instrument as described in any of claims 3 to 7, wherein the ink fed to the ink guiding feed having visibility via the inter-feeder is fed to the pen tip further via a pen tip feeder.

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9. The writing instrument as described in any of claims 3 to 8, wherein the inter-feeder comprises any one of a fiber bundle feed, porous sintered body of resin particles and a sliver feed, and a passage cross-sectional area for an ink flowing through the ink guiding feed can substantially be controlled by providing the inter-feeder with continuous passages while maintaining an apparent cross-sectional area of the ink guiding feed.

10. The writing instrument as described in any of claims 1 to 9, wherein a material of a face of the ink guiding feed having visibility which is brought into contact with the ink or a material of the ink guiding feed itself has a smaller surface tension than that of the ink.

11. The writing instrument as described in any of claims 1 to 10, wherein the occlusion body has a distribution in capillary force such that it is increased toward a pen tip side.

12. The writing instrument as described in any of claims 1 to 11, wherein an inner diameter of the barrel is narrower toward the pen tip side.

13. The writing instrument as described in any of claims 1 to 12, wherein plural ribs are formed in an axial direction on an inner wall of the pen tip side of the barrel.

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14. The writing instrument as described in any of claims 1 to 13, wherein a plurality of the ink guiding feeds having visibility is provided.

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15. The writing instrument as described in any of claims 1 to 14, wherein the ink impregnated into the ink occlusion body is fed to the pen tip through an ink-feeder in addition to the ink guiding feed having visibility.

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16. The writing instrument as described in any of claims 1 to 15, wherein a passage cross-sectional area for the ink flowing through the ink guiding feed and flow resistance of the ink can substantially be controlled by filling the ink guiding feed having visibility with a fiber bundle feed or a porous sintered body of resin particles which has a smaller surface tension than that of the ink and has a color which is different from that of the ink while maintaining an apparent cross-sectional area of the ink guiding feed.

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17. The writing instrument as described in any of claims 1 to 16, wherein the visible part in the barrel has a length of 1 mm or more and not longer than an overall length of the writing instrument.

18. The writing instrument as described in any of claims 1 to 17, wherein the ink guiding feed has an ink passage cross-sectional area of  $8 \times 10^{-2}$  to  $80 \text{ mm}^2$ .

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19. The writing instrument as described in any of claims 1 to 18, wherein the ink has a surface tension of 18 mN/ or more at  $25^{\circ}\text{C}$ .

20. The writing instrument as described in any of claims 1 to 19, wherein the ink has a viscosity of 500 mPa·s or less at  $25^{\circ}\text{C}$ .

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